

Work Order ID 78150

78150

Page 1

December-29-11 10:36:57 AM

Item ID: D2662-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, LH In 206
 Start Date: 29/12/2011 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 06/02/2012 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/12/29 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2662	Rev E

100	HAAS CNC VERTICAL MACHINING #1	0.00							
100									
HAAS 1	Memo	0.00	B.A	12/01/16					
HAAS CNC vertical machine #1	Program part number and batch number. Inspect part number and batch number are programmed		SL	12-01-17					
	MACHINE AS PER FOLIO FB068 & DWG DWG REV: <u>E</u> FOLIO REV: <u>AA</u>								

110	CONVENTIONAL MILLING MACHINE	0.00							
110									
Mill Conv	Memo	0.00	B.A	12/01/16					
Conventional Milling Machine	Machine Keyway and inspect per attached dimension sheet		SL	12-01-17					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 78150

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Page 2

December-29-11 10:36:58 AM

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00	B.A	12/01/16		10	0		
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	ML	12/01/19		10	0		
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							10XCM-12/01/19

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

78150

December-29-11 10:36:58 AM

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 29/12/2011 **Start Qty:** 10.00

10

Cust Item ID:

Required Date: 06/02/2012 **Req'd Qty:** 10.00

10

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00
-----	--	------

150

Powdercoat

Powder Coating

Memo

START TIME:

OVENTEMPERATURE:

FINISH TIME:

0.00-

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: ST 43 0.00

170

Packaging

Packaging

Memo

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

12/1/23 *[Signature]*
12-01-23
/10

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

December-29-11 10:37:01 AM

Page 1

Work Order ID: 78150

78150

Parent Item: D2662-1

D2662-1

Parent Item Name: Saddle, LH In 206

Start Date: 29/12/2011

Required Date: 06/02/2012

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP: C00.06.22Removed P/O for powder coatEC

IPP Rev:D As per Rev D 07-03-19 JLM

IPP REV:D

REDESIGN PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6101-001		Manufactured	No			100	Each	104.0000	1	10			
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D6101-001

Saddle Billet

B.A 12/21/16

Location

Loc Qty

Loc Code

MAT040

104

69677

2

→ 73774

50

74679

6

76836

46

10.0

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 78150
Description: 206 Saddle, Inboard, Left side		Part Number: D2662-1
Inspection Dwg: D2662 Rev: E DSK: Rev:		Page 1 of 2

FIRST ARTICLE INSPECTION DIMENSION SHEET

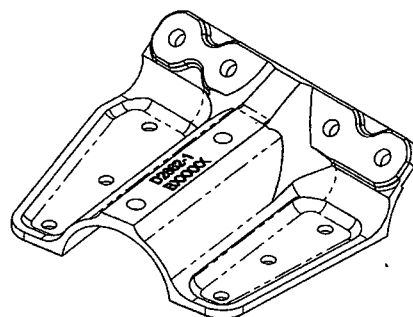
Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	3.611	3.621		3.616	3.616	3.616	3.616	3.616
B	0.256	0.263		0.260	0.260	0.260	0.260	0.260
C	0.315	0.322		0.316	0.316	0.316	0.316	0.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	0.100	0.140		0.125	0.125	0.125	0.125	0.125
G	0.210	0.230		0.221	0.221	0.221	0.221	0.221
H	0.615	0.685		0.685	0.685	0.685	0.685	0.685
I	2.470	2.510		2.490	2.490	2.490	2.490	2.490
J	1.313	1.343		1.324	1.324	1.324	1.324	1.324
K	0.178	0.198		0.188	0.188	0.188	0.188	0.188
L	0.470	0.530		0.500	0.500	0.500	0.500	0.500
M	1.125	1.145		1.138	1.138	1.138	1.138	1.138
N	0.100	0.180		0.135	0.135	0.135	0.135	0.135
O	0.100	0.145		0.136	0.135	0.135	0.136	0.134
P	0.240	0.260		0.249	0.249	0.249	0.249	0.249
Q	0.677	0.697		0.690	0.690	0.690	0.690	0.690
R	0.540	0.560		0.550	0.550	0.550	0.550	0.550
S	0.912	0.932		0.921	0.921	0.921	0.921	0.921
T	0.787	0.807		0.797	0.797	0.797	0.797	0.797
U	5.990	6.010		5.999	5.999	5.999	5.999	5.999
V	4.995	5.005		5.000	5.000	5.000	5.000	5.000
W	0.490	0.510		0.501	0.501	0.501	0.500	0.501
X	0.312	0.319		0.314	0.314	0.314	0.314	0.314
Y	0.990	1.010		0.999	0.999	0.999	0.999	0.999
Z								
AA	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AB	0.490	0.510		0.500	0.500	0.500	0.500	0.500
AC	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AD	0.100	0.140		0.117	0.117	0.117	0.117	0.117
AE	0.235	0.240		0.237	0.237	0.237	0.237	0.237
AF	0.510	0.515		0.512	0.512	0.512	0.512	0.512
AG	0.100	0.120		0.110	0.110	0.110	0.110	0.110
Accept/Reject								

Measured by: K.A.	Date: 12/01/16
Audited by: [Signature]	Date: 12/01/19
Prototype Approval:	Date:

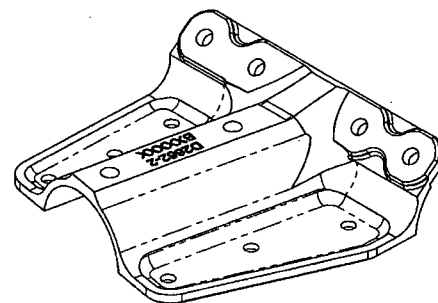
DART AEROSPACE LTD				Work Order: 78150	
Description: 206 Saddle, Inboard, Left side				Part Number: D2662-1	
Inspection Dwg: D2662 Rev: E DSK: Rev:				Page 1 of 2	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				16	17	18	19	10
A	3.611	3.621		3.616	3.616	3.616	3.616	3.616
B	0.256	0.263		0.260	0.260	0.260	0.260	0.260
C	0.315	0.322		0.316	0.316	0.316	0.316	0.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	0.100	0.140		0.125	.120	.121	.121	.121
G	0.210	0.230		0.221	.220	.221	.220	.221
H	0.615	0.685		0.685	0.685	0.685	0.685	0.685
I	2.470	2.510		2.490	2.490	2.490	2.490	2.490
J	1.313	1.343		1.324	1.324	1.324	1.324	1.324
K	0.178	0.198		0.188	0.188	0.188	0.188	0.188
L	0.470	0.530		0.500	0.500	0.500	0.500	0.500
M	1.125	1.145		1.138	1.138	1.138	1.137	1.138
N	0.100	0.180		0.135	0.135	0.135	0.135	0.135
O	0.100	0.145		0.135	.133	.133	.132	.131
P	0.240	0.260		0.248	.248	.248	.248	.248
Q	0.677	0.697		0.690	0.690	0.690	0.690	0.690
R	0.540	0.560		0.550	0.550	0.550	0.550	0.550
S	0.912	0.932		0.921	0.921	0.921	0.921	0.921
T	0.787	0.807		0.797	0.797	0.797	0.797	0.797
U	5.990	6.010		5.999	5.999	5.999	5.999	5.999
V	4.995	5.005		5.000	5.000	5.000	5.000	5.000
W	0.490	0.510		0.500	0.500	.500	.502	.502
X	0.312	0.319		0.314	0.314	0.314	0.314	0.314
Y	0.990	1.010		0.999	0.999	0.999	0.999	0.999
Z								
AA	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AB	0.490	0.510		0.500	0.500	0.500	0.500	0.500
AC	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AD	0.100	0.140		0.118	.120	.117	.120	.117
AE	0.235	0.240		0.237	0.237	0.237	0.237	0.237
AF	0.510	0.515		0.512	0.512	0.512	0.512	0.512
AG	0.100	0.120		0.110	0.110	0.110	0.110	0.110
Accept/Reject								
Measured by: BA/SL				Date: 12/01/16				
Audited by: [Signature]				Date: 12/01/19				
Prototype Approval:				Date:				



D2662-1 SADDLE, INSIDE, LH



D2662-2 SADDLE, INSIDE, RH

STANDARD
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 78150 M.L.J.

11/12/29

RELEASED
2011-11-16
M

E	REDRAW & REFORMAT DWG; 0.687 WAS 0.547 (B8-2,B5-4), REF NCR 11-935	CP	11.10.31
D	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	CB	06.11.08
C	INCORP DEO 8122/9102/9095/8137	CB	06.05.29
B	ANGLE AND NOTES ADDED	KE	97.07.11
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>JP</i>	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	<i>JP</i>		
CHECKED	<i>A.S.</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>JP</i>	D2662	SHEET 1 OF 5
APPROVED	<i>JP</i>	TITLE	SCALE
DE APPR.	<i>JP</i>	SADDLE, INSIDE	NTS
DATE	11.10.31	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS COVENANT THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

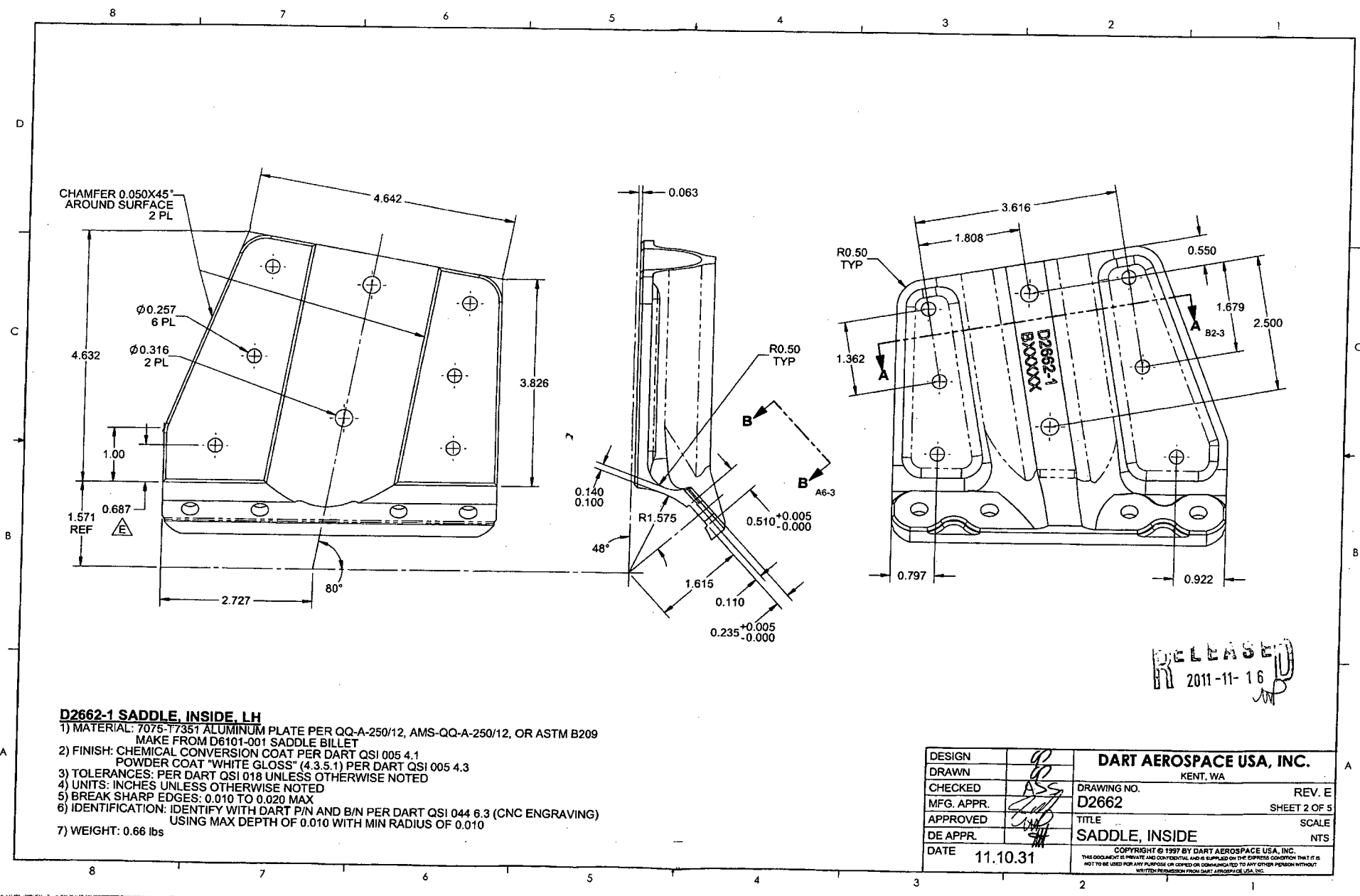
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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78150



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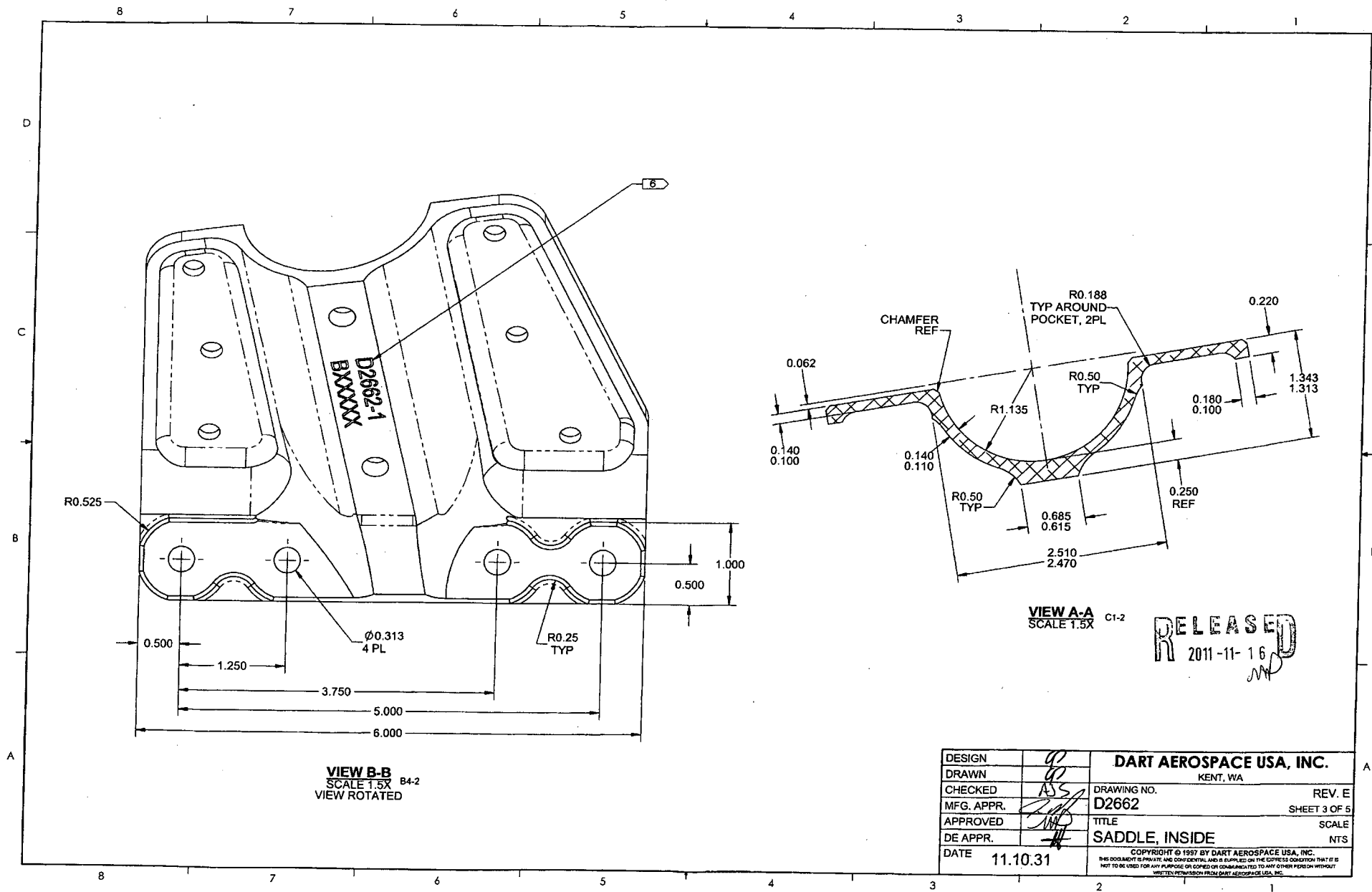
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NOTE: Date & initial all entries

78150



VIEW B-B
SCALE 1.5X B4-2
VIEW ROTATED

VIEW A-A C1-2
SCALE 1.5X

RELEASED
2011-11-16

DESIGN		DART AEROSPACE USA, INC.	
DRAWN	<i>g</i>	KENT, WA	
CHECKED	<i>ASS</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D2662	SHEET 3 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SADDLE, INSIDE	NTS
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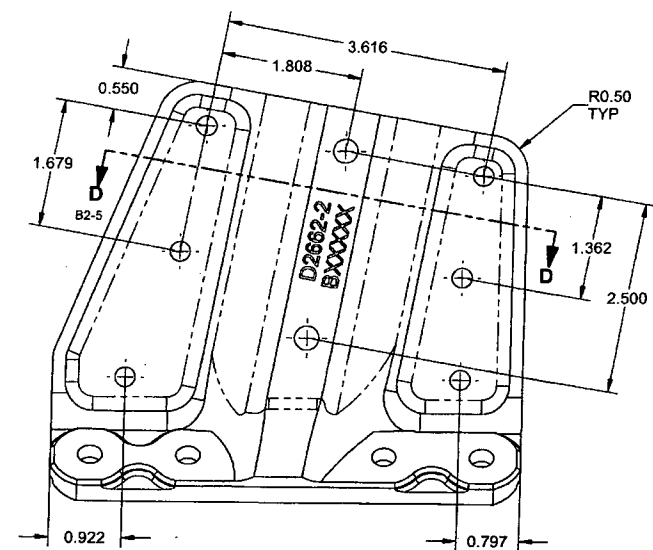
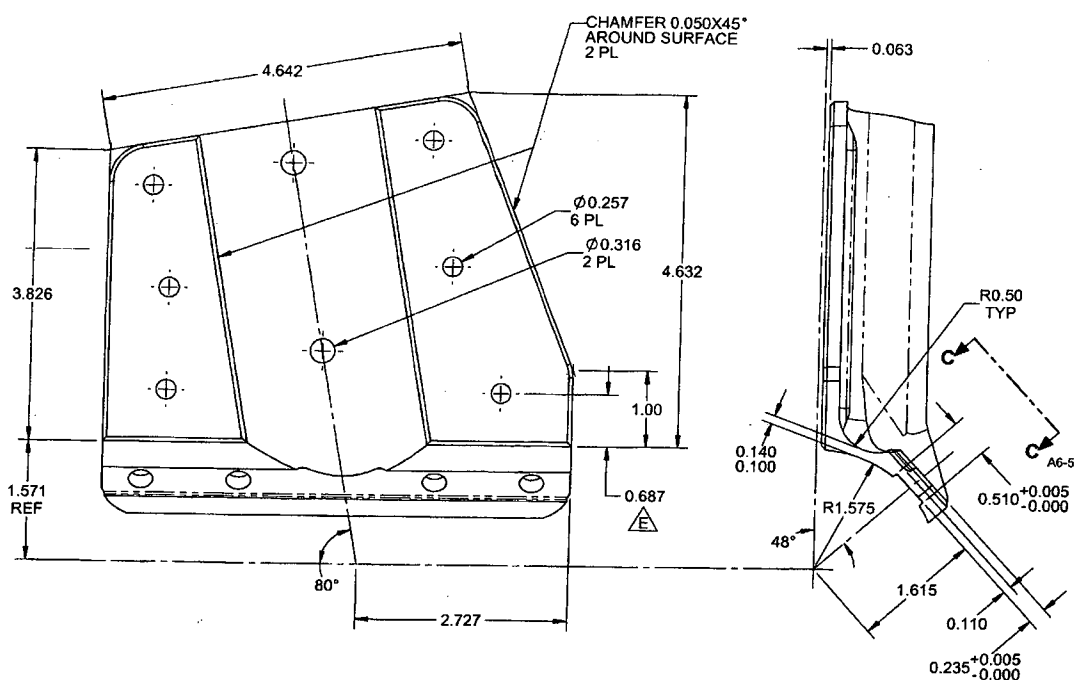
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RELEASED
2011-11-16
MM

D2662-2 SADDLE, INSIDE, RH

- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
MAKE FROM D6101-001 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
- 7) WEIGHT: 0.66 lbs

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2662	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SADDLE, INSIDE	NTS
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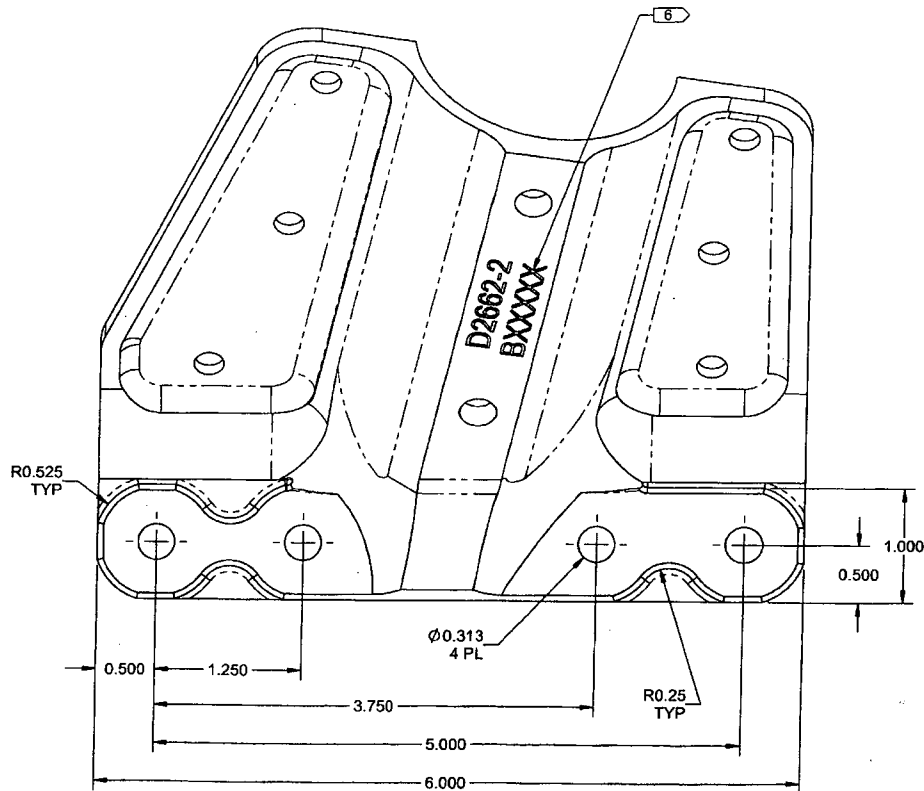
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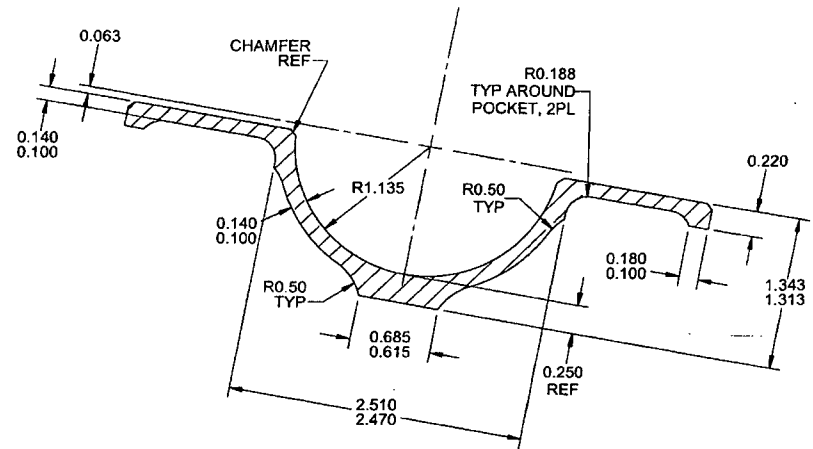
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NOTE: Date & initial all entries

70150



VIEW D-D
SCALE 1.5X B4-4
VIEW ROTATED



VIEW C-C
SCALE 1.5X C3-4

RELEASED
2011-11-16

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2662	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SADDLE, INSIDE	NTS
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries